

Date: Wednesday, 15/04/2009 9:46:37 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 47177		
Estimate Number	: 10271		
P.O. Number	:	Part Number	: D2561
This Issue	: 15/04/2009 S.O. No. :	Drawing Number	: D2561 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 40935	Material	:
Written By	:	Due Date	: 20/04/2009 Qty: 40 Um: Each
Checked & Approved By	: <u>JLD 09.04.15</u>		
Comment	: Est C 00.05.19 Added inspect level 8 EC Est Rev:D Now on Waterjet 06-06-14 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .250 x 6.00
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Comment: Qty.: 0.3850 f(s)/Unit Total : 15.4014 f(s)  
 Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick  
 Batch: 110913 B 9-S-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2561  
 Dwg Rev: B B 9-S-21  
 Prog Rev: B

(48)

2-Deburr if necessary B 9-S-21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 09/05/21 48 count

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr , no sharp edges

M. H 09/05/28 48X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 47177

Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



cont

Comment: INSPECT WORK TO CURRENT STEP

09/05/29

x48

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

09.05.29

48

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

09.05.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

09-05/2

☒ **First Article**      ☐ **Prototype**

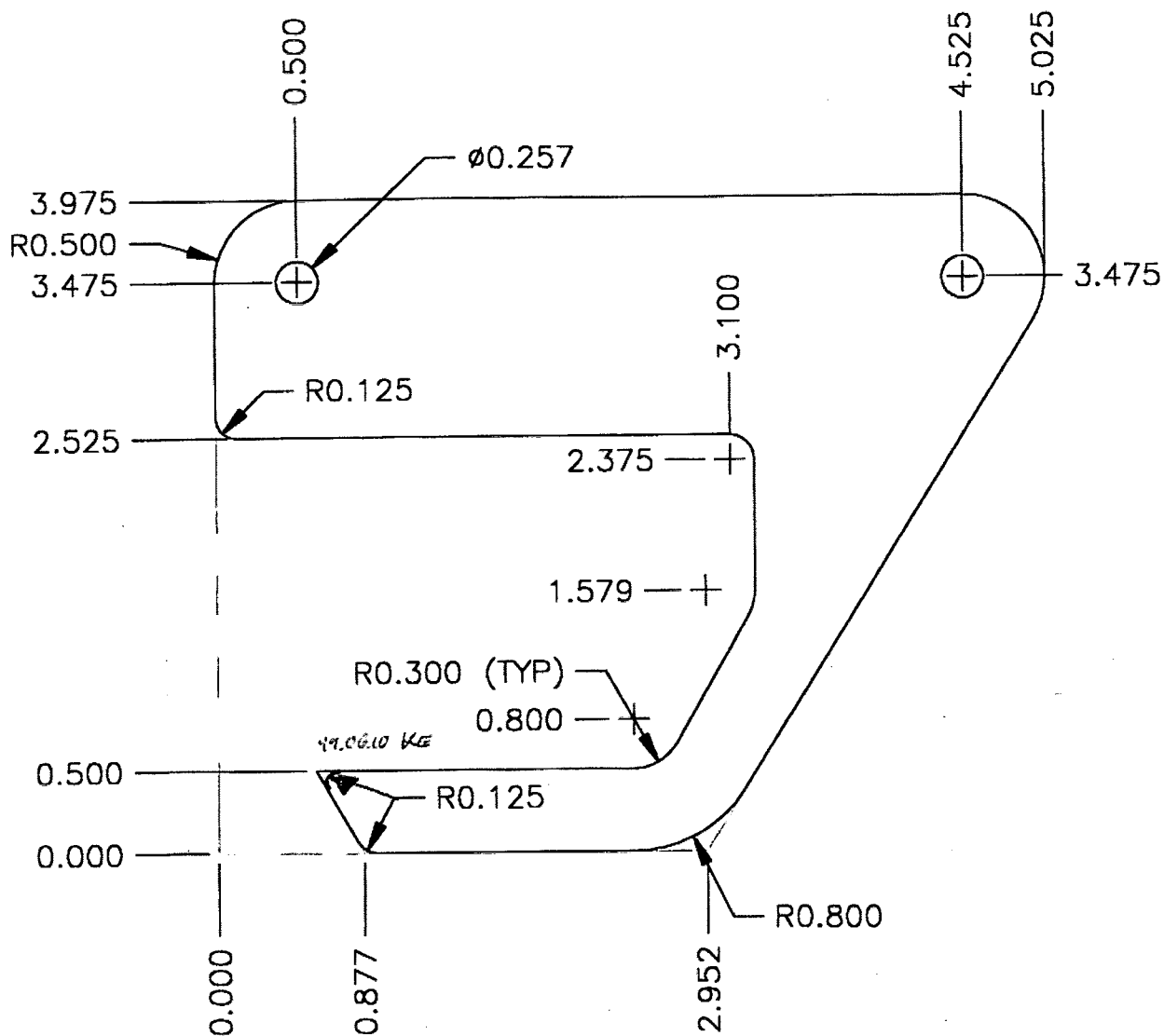
Measured by:	JB	Audited by:	8	Prototype Approval:	N/A
Date:	9-5-21	Date:	09/05/21	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revD



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2561	SHEET 1 OF 1
DATE		TITLE	SCALE
96.04.26		LUG PLATE	1:1

RELEASED  
96 05 06



MATERIAL: 6061-T6 0.25 THICK  
OR 6063-T6 0.25 THICK  
OR 5052-H34 0.25 THICK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4777